



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2892-1**Job Sheet 206906**

Part No: D2892-1

Job Qty: 8 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/20

Job Tracking No:

Due Date: 2/27/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2892 REV C IPP C 02.11.26 Added P/O KJ/IPP D 08.03.19 Re-format EC verified by:DD/IPP Rev:E
11.08.04 as per dwg rev.B DD verf:EC/IPP Rev. C 19.12.02 drawing revision DP Verify DD

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	2/27/20	2/27/20	0.36	5.08	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	6 pcs	2/27/20	2/27/20	0.00	0.00	QC 2 - 1		M. Lajeunesse
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		M. Lajeunesse 20/03/20
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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Container No: S260442



Part: D2892-1

Job No: 206906

Serial No/Batch: S260442

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/03/20

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
120 QC 8	6 pcs	2/27/20	0.00 0.00	QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	11-20/03/04
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Crosstubes - 2 - B4B	6 pcs	2/27/20	0.00 0.97	Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	
				Crosstubes - 3 - B4B	DAS
				Crosstubes - 4 - B4B	141 MAR 17 2020
140 QC 3	6 pcs	2/27/20	0.00 0.00	QC 3 - 10	9-89
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DAS
				QC 3 - 19	MAR 23 2020 40
					9-89
				Plex 2/13/20 12:56 PM Dart.lajeunesse.marie	

				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
170 Packaging 3-1 - Stock - B4B 6 pcs	2/27/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 74 MAR 24 2020
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA 6 pcs	2/27/20	0.00 0.00		QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21
				QC 21 - SA - 53	5-89 MAR 24 2020
Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA082 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - (QC8- Inspect parts - second check) 130 - (Crosstubes) Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and use DT10659 apply 3M Scotch-Weld as per dwg. 24h of cure time 5206999 exp 8/21 140 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location:) LOCATION : LG050 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
DSK077	D2892-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	5200 868	

Job Allocations					
Operation 100-HAAS 4 Axis	Component Part DSK077	Required 3	Inventory 4	Allocated 0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
2	2.250 Support	0.290Inches + 0.020 - 0.000	0.310 0.290		
3	2.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
4	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
5	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
6	2.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
7	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
8	2.250 Support	1.116Inches + 0.040 - 0.000	1.156 1.116		
9	2.250 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
10	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
12	2.250 Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
13	2.250 Support	1.663Inches + 0.020 - 0.000	1.683 1.663		
14	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
15	2.250 Support	0.022Inches + 0.020 - 0.000	0.042 0.022		
16	2.250 Support	2.779Inches + 0.010 - 0.000	2.789 2.779		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

DART AEROSPACE LTD		Work Order: 206906
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.150		.133	.134	.130	.130	.133
AB	0.290	0.310		.300	.305	.300	.300	.300
AC	0.040	0.060		.051	.050	.049	.047	.050
AD	0.115	0.150		.124	.125	.128	.125	.124
AE	0.240	0.260		R.250 x	R.250 x	.250	.250	.250
AF	0.188	0.193		.189	.190	.191	.192	.192
AG	0.240	0.260		R.250 x	R.250 x	.250	.250	.250
AH	1.116	1.156	1.145	1.144	1.143	1.138	1.140	1.140
AI	0.454	0.474		.467	.466	.468	.468	.468
AJ	0.240	0.260		R.250 x	R.250 x	.250	.250	.250
AK	0.053	0.073		R.063 x	R.063 x	.063	.063	.063
AL	0.257	0.262		.257	.257	.257	.257	.257
AM	1.663	1.683		1.678	1.677	1.676	1.676	1.677
AN	0.053	0.073		R.063 x	R.063 x	.063	.063	.063
AO	0.022	0.042		R.032 x	R.032 x	.032	.032	.032
AP	2.779	2.789		2.784	2.782	2.782	2.782	2.782
AQ	.090	.110		.095	.095	.095	.095	.095
AR	3.680	3.740		3.71	3.71	3.71	3.71	3.71
AS								
AT								
Accept/Reject								

Measured by: M.M. 64	Date: 2020/03/02
Audited by: [Signature]	Date: 2020/03/04
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	[Signature]

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DART AEROSPACE LTD		Work Order: 206906
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.115	0.150		.135	.133	.132		
AB	0.290	0.310	270 / 330	.300	.300	.300		
AC	0.040	0.060		.049	.048	.048		
AD	0.115	0.150		.124	.124	.124		
AE	0.240	0.260		.250	.250	.250		
AF	0.188	0.193		.192	.192	.192		
AG	0.240	0.260		.250	.250	.250		
AH	1.116	1.156	1.145	1.138	1.141	1.138		
AI	0.454	0.474		.464	.464	.464		
AJ	0.240	0.260		.250	.250	.250		
AK	0.053	0.073		.063	.063	.063		
AL	0.257	0.262		.257	.257	.257		
AM	1.663	1.683		1.675	1.673	1.675		
AN	0.053	0.073		.063	.063	.063		
AO	0.022	0.042		.032	.032	.032		
AP	2.779	2.789		2.782	2.782	2.782		
AQ	.090	.110		.097	.095	.094		
AR	3.688	3.740		3.71	3.71	3.71		
AS								
AT								
Accept/Reject								

Measured by: MML	Date: 20/03/03
Audited by: DAS	Date: 2020/03/04
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	